

Work Order ID 105611

Thursday, August 08, 2013 2:34:41 PM

105611

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Item ID: D3873-1

Revision ID:

Item Name: Bushing

Start Date: 8/8/2013 Start Qty: 200.00

Required Date: 8/22/2013 Req'd Qty: 200.00

Reference:

Approvals: Process Plan: MCT

QC:

Date: 13-08-08 Tooling:

Date: SPC (Y/N):

N9000040100

Cust Item ID:

Customer:

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D3873 C

100 0.00

100

Hardinge

Hardinge CNC Lathe Small

Memo

1-TURN AS PER FOLIO FA806 & DWG D3873

FOLIO REV: 44

DWG REV: 44

2-DEBURR AS REQUIRED

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

0.00

2 13.8.12 300 0
DAS 44 13/08/13
9-83

2 13.8.12 300 0
DAS 44 13/08/13
9-83

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Item ID: D3873-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 8/8/2013 Start Qty: 200.00

200

Cust Item ID:

Required Date: 8/22/2013 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

A.A 13/08/16

300

φ

DAS
08
9-89

130

Identify as per dwg & Stock Location: 31068 0.00

130

Packaging

Memo

0.00

Packaging

300X 11.10.13-08-16

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

13/8/2016

MCS 13-08-16

05

Picklist Print

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Work Order ID: 105611

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Parent Item: D3873-1

D3873-1

Parent Item Name: Bushing

Start Date: 8/8/2013

Required Date: 8/22/2013

Start Qty: 200.00

Required Qty: 200.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.625		Purchased	No			100	f	108.5417	0.06	12.63158			

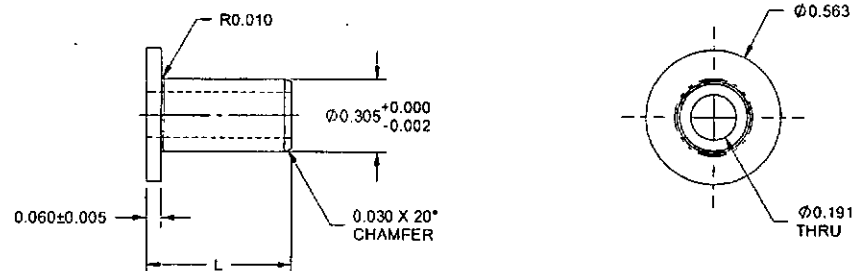
M303R0 625

303 Round Bar 0.625"

**

Location	Loc Qty	Loc Code
MAT028	108.54171	
118400	4	
119009	0.00001	
119766	65.629	
124081	38.9127	

18.95' DAS
9-83 13/08/13



D3873-X BUSHING



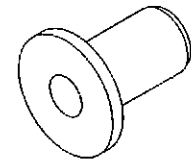
DART P/N	L	WEIGHT (lbs)
D3873-1	0.600	0.010
D3873-3	0.120	0.005
D3873-5	0.270	0.007

NOTES:

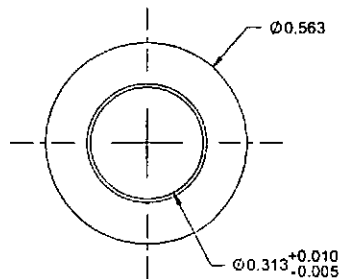
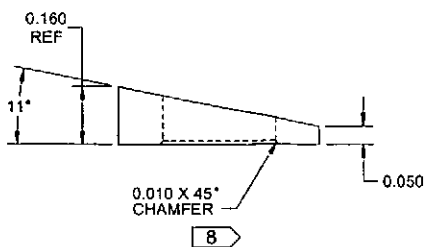
- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

C	ADD D3873-3/5/7 (ZN B6-1 & B5-2)	RF	11.06.14
B	$\phi 0.563$ WAS $\phi 0.63$ (C3-1, TO FIT TRIBAG GIRT)	CP	10.07.22
A	NEW ISSUE	MB	09.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC	DRAWING NO.	REV. C
CHECKED	97	D3873	SHEET 1 OF 2
MFG. APPR.	E	TITLE	SCALE
APPROVED	14	BUSHING	NTS
DE APPR.	14	DATE 11.06.14	
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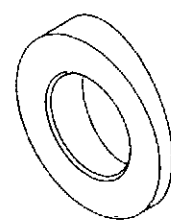
RELEASED
R 2011-09-12
JWP



105611



C D3873-7 SPACER



- NOTES:
- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.005 lbs
 - 8) IT IS ACCEPTABLE TO BE DEBURR

RELEASED
2011-09-12
NY

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3873	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BUSHING	NTS
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